

Date: Monday, 1/29/2007 11:13:00 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARPAW INSTALLATION
Job Number	: 30488		
Estimate Number	: 10044		
P.O. Number	: N/A	Part Number	: D044662011
This Issue	: 1/29/2007	S.O. No.	: N/A
Print Rev.	: NC	Drawing Number	: D3075 UNDER REVIEW <i>cb</i>
First Issue	: N/A	Project Number	: N/A
Previous Run	: 30196	Drawing Revision	: A2
	Type : MACHINED PARTS	Material	: N/A
Written By	: <i>[Signature]</i>	Due Date	: 2/12/2007
Checked & Approved By	: <i>[Signature]</i> 07.01.29	Qty:	<i>6</i> Um: Each
Comment	: Est Rev: C 04.02.19 Added tolerance and ref to DSK086-12 to Step 3 KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	30488A	UNDER REVIEW R44 BEARPAW



Comment: Sub-Component R44 BEARPAW

2.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPPD044-662-011 CHG002

*07.01.29**KS*

3.0	D2182B	Neoprene Cushion-.750 bl
-----	--------	--------------------------



Comment: Qty.: 0.9300 f(s)/Unit Total: 4.6500 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2182B028 Rubber Cushion *B30397*

1 Paperwork package

4.0	D2274	Radius Block
-----	-------	--------------



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2274 Radius Block *B30380*

5.0	D2529	Washer
-----	-------	--------



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2529 Washer *B28733*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/29/2007 11:13:00 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW INSTALLATION

Job Number: 30488

Part Number: D044662011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2882

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3075-1 Bearpaw(REF)

4 D2882 Clamp

B24505 ✓

7.0

AN414A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN4-14A Bolt

M102473 ✓

8.0

AN415A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN4-15A Bolt

M103585 ✓

9.0

AN960JD416

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN960JD416 Washer

M103338 ✓

10.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4 Nut (or -4)

M103349 ✓

EPO7/03/01 ©

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: AP Date: 07/13/06

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/29/2007 11:13:00 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW INSTALLATION

Job Number: 30488

Part Number: D044662011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

*PC 7/3/05 (6)*

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D044-662-011

Location: *NWB*

*PC 7/3/05 (6)*

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*207103/06 (6)*

Job Completion



*U 07.03.06*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/29/2007 11:13:03 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: UNDER REVIEW R44 BEARPAW
Job Number	: 30488A		
Estimate Number	: 10100	Part Number	: D30751
P.O. Number	: N/A	Drawing Number	: UNDER REVIEW <i>CB</i> 07.01.29
This Issue	: 1/29/2007 S.O. No. : N/A	Project Number	: N/A
Plsht Rev.	: NC	Drawing Revision	: A2
First Issue	: N/A Type : MACHINED PARTS	Material	: N/A
Previous Run	: 30196A	Due Date	: 2/12/2007
Written By	: <i>[Signature]</i>	Qty:	<i>10</i> Um: Each
Checked & Approved By	: <i>[Signature]</i> 07.01.29		
Comment	: Est Rev: 04.02.19 Added tolerance and ref to DSK086-12 to Step 3 KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	MUHMWB10	UHMW 1" Black
-----	----------	---------------



Comment: Qty.: 1.8949 sf(s)/Unit Total : 18.9490 sf(s)

Pick:

blank: 10.50" x 13.00" x 1.00" thick (+0.030/-0.000) per DSK086-12

Material: Black UHMW 1"(MUHMWB10)

Batch: *M101627*

*SD 07.02.26*

*C*

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA185 and Dwg D3076 Identify as D3075-1

3-Deburr

*ml/SD 07.02.26*

*C*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*ml/SD 07.02.26*

*C*

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

*SD 07/02/28*

*C*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 1 Date: 07/03/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Monday, 1/29/2007 11:13:03 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UNDER REVIEW R44 BEARPAW

Job Number: 30488A

Part Number: D30751

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PPP 2044-662-011

B 30488

7/3/5 (6)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/06

Job Completion



11 07-03-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 30488A
<b>Description:</b> R44 Bearpaw		<b>Part Number:</b> D3075-1
<b>Inspection Dwg:</b> D3075	<b>Rev:</b> A2	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

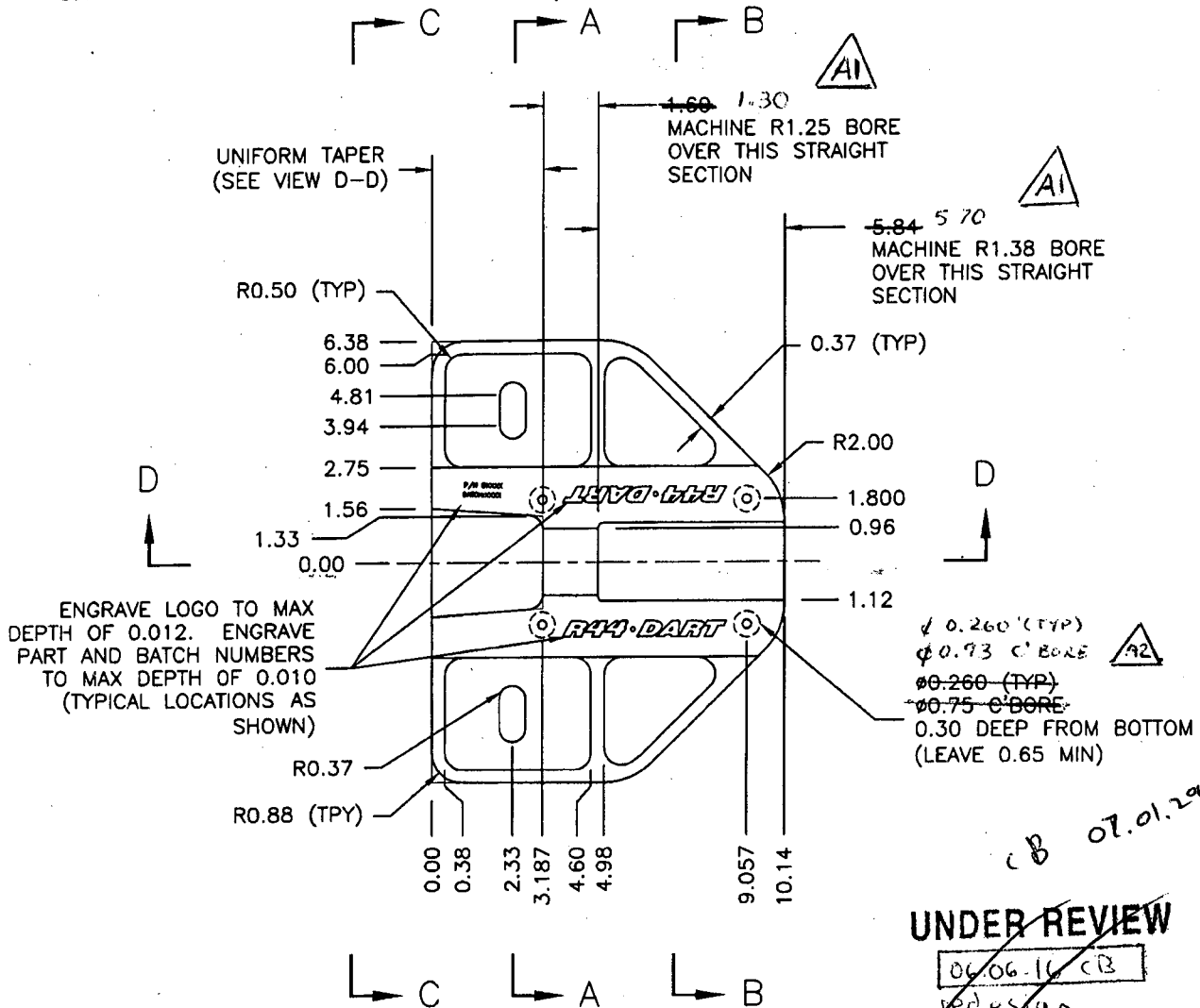
Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.07 x 45°	+0.030/-0.010	.05 x 45	/			
B	0.63	+/-0.030	.610	/			
C	0.250	+/-0.010	.242	/			
D	0.950	+0.030/-0.010	.947	/			
E	5.50	+/-0.030	5.500	/			
F	0.25 x 45°	+/-0.030	.27 x 45°	/			
G	0.900	+/-0.010	.890	/			
H	0.375	+/-0.010	.370	/			
I	1.30	+/-0.030	1.30	/			
J	5.70	+/-0.030	5.706	/			
K	0.37	+/-0.030	.380	/			
L	3.600	+/-0.010	3.600	/			
M	0.260	+0.005/-0.000	.260	/			
N	0.93	+/-0.030	.930	/			
O	0.30	+0.030/-0.000	.315	/			
P	1.08	+/-0.030	1.08	/			
Q	5.870	+/-0.010	5.870	/			
R	10.14	+/-0.030	10.14	/		Tape	

<b>Measured by:</b> SA	<b>Audited by:</b> En	<b>Prototype Approval:</b> N/A
<b>Date:</b> 07.02.26	<b>Date:</b> 07/02/26	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A	04.01.13	New Issue P/O D044-662-011	KJ/RF	#

**DART**

DESIGN 	DRAWN BY 	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3075	REV. A SHEET 1 OF 2
DATE 02.01.04		TITLE R44 BEARPAW	SCALE 1:5
A	02.01.04	NEW ISSUE	
A1	RF 02.02.01	1.30 WAS 1.60 ; 5.70 WAS 5.84	
A2	RF 03.01.06	ø 0.93 WAS ø 0.75	

**RELEASED**  
02.01.10

D3075-1 BEARPAW

**NOTES:**

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00" THICK (MACHINE TO 0.950)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **30488A**

Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

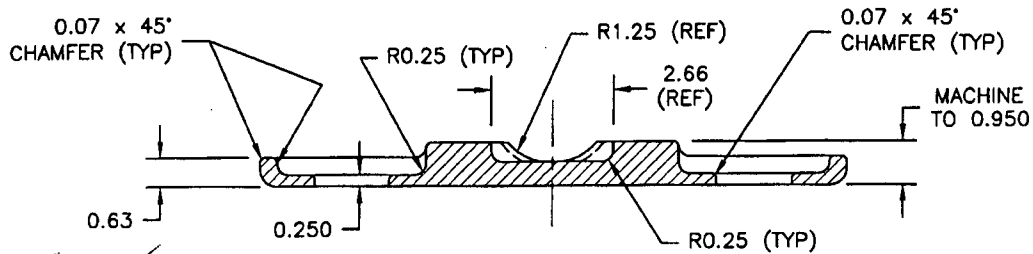
**DART**

DESIGN #	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3075	REV. A SHEET 2 OF 2
DATE 02.01.04	TITLE R44 BEARPAW		SCALE 1:4

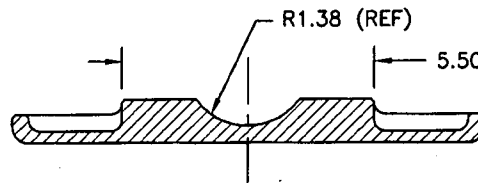
RELEASED  
02.01.10

UNDER REVIEW

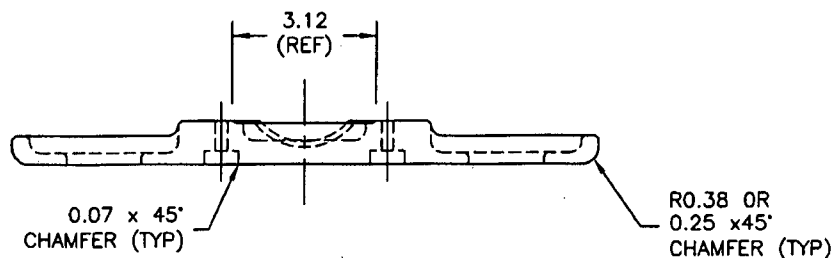
06.06.16 CB  
redesign  
CB 07.01.29



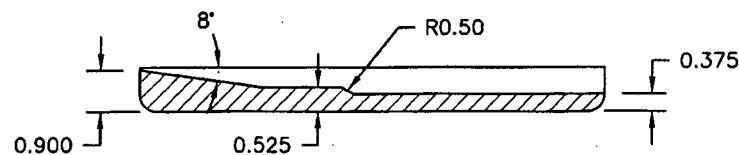
SECTION A-A



SECTION B-B



SECTION C-C



SECTION D-D

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30488A

Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Date: Thursday, 23/08/2007 3:13:27 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: UPDATE PAPERWD044-662
Job Number	: 34262		
Estimate Number	: 10804		
P.O. Number	: N/A	Part Number	: Z_CUSTOM
This Issue	: 23/08/2007 S.O. No. : N/A	Drawing Number	: ECN 1021
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: N/A
Previous Run	: 34248	Material	: N/A
Written By	: <u>W</u>	Due Date	: 30/08/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>W</u>		
Comment	:		

## Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ADD NEW PAPERWORK TO STK  
 PER ECN 1021

13 D044-662-011 B/N

30488

5X

11 D044-662-013 B/N

31589

14X

RETURN TO STK

7/8/24 SP

2.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D044-662-013

Job Completion



11 27-08-24